

Work Order ID 50746

July 21, 2009 12:43:54 PM



Page 1

Item ID: D2022-101

Accept



Setup Start



Revision ID: N/A

Stop



Item Name: Spacer

Start Date: 7/03/09

Start Qty: 100.00



Cust Item ID:

Required Date: 7/06/09

Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Note: .257(F) Dia drill 12-Turn Blank as per Folio FA206113-Tumble & deburr any sharp edges as per dwg

NA 09/07/24

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

NA 09/07/24

100

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

NA 09/07/24 100

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Page 2

Item ID: D2022-101

Revision ID: N/A

Item Name: Spacer

Start Date: 7/03/09 Start Qty: 100.00

Required Date: 7/06/09 Req'd Qty: 100.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 304

0.00



Packaging

Memo

0.00

Packaging

9/1/27 27 (100x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/28 28

ME 09-07-28

Status	Item ID	Rev	Name	Start Date	Quantity	PeJO	Map Date	Secrap	ap	Qua	mmeind	N	C	IECX	I	Sortme	Offsean	Ty1	Per	Och	to	Yore	Ce	Last	dd	Da
✓	M6061T6R0.750		6061-T6 Round B...	6/24/09	0.0300	f		100	0	0.0...						1	0	M...						6/3...	6/...	

Picklist Print

July 23, 2009 6:59:46 AM

Work Order ID: 50746

Parent Item: D2022-101RevN/A

Parent Item Name: Spacer

Comments:

Start Date: 7/03/09

Required Date: 7/06/09

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No				f	22.9700	3.0000			



6061-T6 Round Bar .750"



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	22.97	
110791	2.97	
112041	20	

J. A 09-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

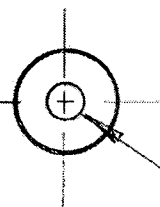
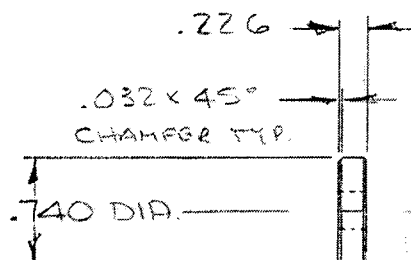
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
770119 BW

40 50746



D2022-101
D7022-103

DRILL F (257) DIA. IN -101
DRILL P (.323) DIA IN -103

MAT'L: ALUMINUM 6061-T6 (20-A-225/E)



2022

D2022-103	SPACER 5/16	ALUM 6061-T6	20-A-250/B
D2022-101	SPACER 1/4	ALUM 6061-T6	20-A-250/B

REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		REVET CODE SHALL BE PER NAS 521		QTY. REQUIRED		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC./VENDOR	
DRAWN				BASIC CODE		DIN DASH NO B-HEAD NEAR SIDE F-HEAD FAR SIDE		CONTRACT NO.		DATE		CLIENT		DART AERO ACCESSORIES INC			
APPROVED				D-DIMPLE D-DIMPLE NO OF SPACERS C-COORDINATING		LENGTH DASH NO W-SHOULDER		DRAWN BRADLEY		DESIGN BRADLEY		STRESS		CHECKED		CLIENT	
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES				TITLE SPACERS		CODE D2022		SCALE 1:1		SHEET 1 OF 1		REV.	
		1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHNESS 125 3. REMOVE SHARP EDGES 0.125 MAX 4. THREADS PER ANS. C-1.75-2 5. HOLE PER ANS. 10.5-11		1. TOLERANCES - AS X 0.00 2. ANGLES - AS X 0.10 3. PARALLELISM - 0.005 4. ECCENTRICITY - 0.005 MAX 5. SYMMETRY ABOUT ALL MFC CENTRE LINES 0.01		BASIC CODES											
REPORT ALL DISCREPANCIES - DO NOT SCALE																	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries